

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020676**Date Inspected:** 10-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Xie Ming Feng, CWI as Sha Zhi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 13AE

PCMK: SEG3007AX

Weld No: 009

Welder: 050242

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Xie Ming Feng, CWI as Sha Zhi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Components; 13AE (see photos below)

PCMK: SEG3019AP

Weld No: 004

Welder: 215993

WPS-B-T-2221-B-L2C-S-2

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng, CWI as Sha Zhi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 13AE

PCMK: SEG3007E

Weld No: 192

Welder: 068924

Weld Repair: WR19468

WPS-345-SMAW-1G(1F)-FCM-Repair

Components; 13AE

PCMK: SEG3007V

Weld No: 459

Welder: 044772

WPS-B-P-2114-FCM-1

Bay 19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder, Suspender Brackets SB108E, SB106W, and SB106E in the center area of bay 19;

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA Inspector was present. (see photo below)

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder, Bike Path BK004-013, BK004-002, and BK004-014 in the east end of bay 19;

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA Inspector was present.

Bay 28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder, Splice Plates SA3103B, SA3117D, and Guard Rails in the west end of bay 28;

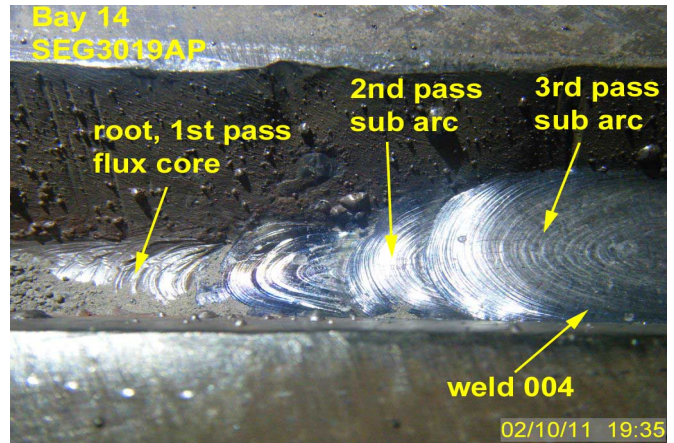
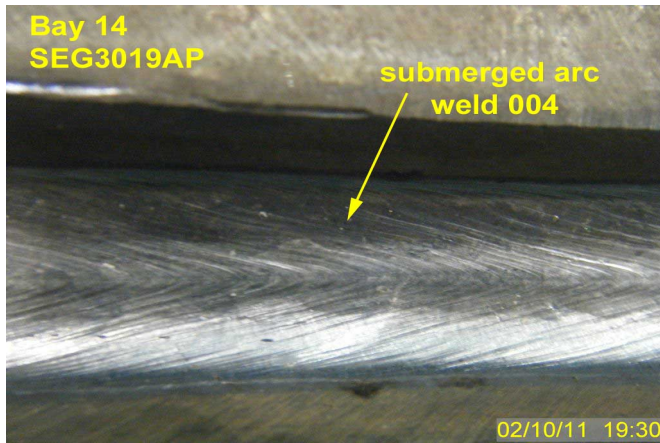
This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA Inspector was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer